# Work Order ID 116819

*April-24-14 7:47:36 AM*

*116819*



**Item ID:** D2565-201 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Strut

**Start Date:** 4/23/14 **Start Qty:** 6.00 *6* **Cust Item ID:**

**Required Date:** 4/23/14 **Req'd Qty:** 6.00 *6* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** MLJ **Date:** 14-04-25 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D2565 | Rev E | | | | | | | | |
| 100 | Punch ends and deburr as per dwg | 0.00 | | | DAS 30 9-89 | 6 | | | 14/04/24 |
| *100* | NC BRAKE | | | | | | | | |
| Brake NC | **Memo** | 0.00 | | | | | | | |
| Brake NC | Punch as per Dwg D2565 using DT 8313 | | | | | | | | |
| 110 | | 0.00 | | | DAS 36 9-89 | | | | |
| *110* | Small Fab | | | | | 6x | | | 14/07/24 |
| Small Fab | **Memo** | 0.00 | | | | | | | |
| Small Fab | Drill hole as per Dwg D2565 (one end only)<br>Deburr | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | 6 | | | |
| *120* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14/7/24

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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_____

# Work Order ID 116819

*April-24-14 7:47:36 AM*

*116819*



**Item ID:** D2565-201 **Accept** *N9000401100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Strut

**Start Date:** 4/23/14 **Start Qty:** 6.00 *6* **Cust Item ID:**

**Required Date:** 4/23/14 **Req'd Qty:** 6.00 *6* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | DAS 41 9-89 |
| *130* | 128959 | | | | | 6 | ø | ø | |
| Powdercoat | **Memo** | 0.00 | | | | | | | 14-7-27 |
| Powder Coating | START TIME: 2:25<br>OVEN TEMPERATURE: 400°<br>FINISH TIME: 255 | | | | | | | | |
| 140 | QC3- Inspect Part Finish | 0.00 | | | | | | | DAS 27 9-89 |
| *140* | | | | | | 6 | | | 14/7/28 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | DAS 32 9-89 |
| *150* | ST 354 | | | | | 14/7/28 | | | (6) |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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# Work Order ID 116819

*April-24-14 7:47:37 AM*

*116819*

**Item ID:** D2565-201 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:**

**Item Name:** Strut **Stop** *NS2*

**Start Date:** 4/23/14 **Start Qty:** 6.00 *6*

**Required Date:** 4/23/14 **Req'd Qty:** 6.00 *6*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14/7/28

14.7.28

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

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☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
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☐ Positioned Wrong
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☐ Temperature/Cure
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☐ Wrong Stock Pulled
☐ Other

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# Picklist Print

*April-24-14 7:47:40 AM*



**Work Order ID:** 116819

*116819*

**Parent Item:** D2565-201

*D2565-201*

**Parent Item Name:** Strut

**Start Date:** 4/23/14 **Required Date:** 4/23/14

**Start Qty:** 6.00 **Required Qty:** 6.00

**Comments:** IPP: D01.06.04Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 170.7591 | 1.9166 | 12.10484 | | | DAS 30 9-89 |

*M304TR0.750W.049*

304 RD Tube .750 x .049W

**

14/06/10

| Location | Loc Qty | Loc Code |
|---|---|---|
| MAT017 | 170.7591 | |
| 122312 | 6 | |
| 124768 | 49.27 | |
| M126183 | 26.0959 | |
| M128084 | 89.3932 | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

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| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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# DART AEROSPACE LTD

| | | | |
|---|---|---|---|
| Description: | Strut | Work Order: | 116819 |
| Inspection Drawing: | D2565 | Rev: C | Part Number: D2565-201 |

## INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 22.79 | +/-.030 | 22.79 | ✓ | | T | SB-6 |
| 22.00 | +/-.030 | 22.00 | ✓ | | T | SB-5 |
| Ø 316 | | | | | | |

| Measured by: | Checked By: | QC inspector: | Engineering Approval (*if necessary*) |
|---|---|---|---|
| ~~DAS~~ 30 9-89 | DAS 30 9-89 | | |
| Date 14/06/10 | Date 14/06/10 | Date 14/7/24 | Date |